

Date: Thursday, 10/04/2008 4:00:35 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT MAINTENANCE STEP
Job Number : 38537	
Estimate Number : 12455	
P.O. Number :	Part Number : D350591133
This Issue : 10/04/2008 S.O. No. :	Drawing Number : D2946 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : REV. B
Previous Run : 35671	Material :
Written By :	Due Date : 28/04/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JD 08.4.10</u>	
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:B 06.07.19 D2946 @ rev.b EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

JD 08/05/08 8:42

2.0	D2622120C
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Comment: Qty.: 0.50000 Each(s)/Unit Total : 3.00000 Each(s)

Pick:

Qty Part Number

Description Batch

800 D2622-120C

Extrusion

335618 C1
335623 (5)

SAD 08/04/17

3.0	LARGE FAB 1
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LARGE FABRICATION RESOURCE 1

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Debur

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

SAD 08/04/17 (6)

4.0	QC5
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INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

5.0	D2734
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**Comment:** Qty.: 2.00000 Each(s)/Unit Total : 12.00000 Each(s)

Pick:

Qty Part Number

Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2734

End Plate 836520

Ph 08.04.28

6.0

D2944



comp. pulled 4
35689



Comment: Qty.: 2.00000 Each(s)/Unit Total: 12.0000

Pick:

Qty Part Number Description Batch

2 D2944 Support 335689 =
336405 =

- 8 - 36405

Ph 08.04.28

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

Ph 08.04.28

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M106834
M106762

Ph 08.04.28

3-Grind End Cap welds flush

SAD 02/04/29

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ph 08.04.30

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/04/30

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-30

Ph 08.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #: Machine Or Operation: Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M106834

08/05/06

08 05.05 6

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

08/05

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-05-06

1235059113

06/05/2008

S.195

14.36

#1

318.6

#2

#3

30m

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2946 and QSI 005 4.3

08-05-06

26

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08/05/08

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D22301



Comment: Qty.: 4.00000 Each(s)/Unit Total: 24.00000 Each(s)

Mounting Lug

Batch: 38740

SP

21.0

D22303



Comment: Qty.: 4.00000 Each(s)/Unit Total: 24.00000 Each(s)

Mounting Lug

Batch: 37918

SP

22.0

D2856400



Comment: Qty.: 1.26063 f(s)/Unit Total: 7.56378 f(s)

Abrasion Strip 7.20" long x2

Batch: 36161

SP

23.0

D2945



Comment: Qty.: 1.00000 Each(s)/Unit Total: 6.00000 Each(s)

Step Mounting Plate

Batch: 38557 35690

SP

24.0

AN47A



Comment: Qty.: 2.00000 Each(s)/Unit Total: 12.00000 Each(s)

Bolt

Batch: 102140

SP

25.0

AN411A



Comment: Qty.: 4.00000 Each(s)/Unit Total: 24.00000 Each(s)

Bolt

Batch: 107214 (17x) 106605 (7x)

SP

26.0

AN414A



Comment: Qty.: 8.00000 Each(s)/Unit Total: 48.00000 Each(s)

Bolt

Batch: 105653

8/5/7

6x

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416



Comment: Qty.: 14.00000 Each(s)/Unit Total : 84.00000 Each(s)

Washer

Batch: 107321

SP

28.0

MS21042L4



Comment: Qty.: 14.00000 Each(s)/Unit Total : 84.00000 Each(s)

Nut

Batch: 106051

8/5/7

bx

SP

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/05/08 (x6)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: 0

PPP Rev: 0

8/5/8

bx

SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/08

Job Completion



u 08/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D2946 STEP ASSEMBLY PARTS LIST

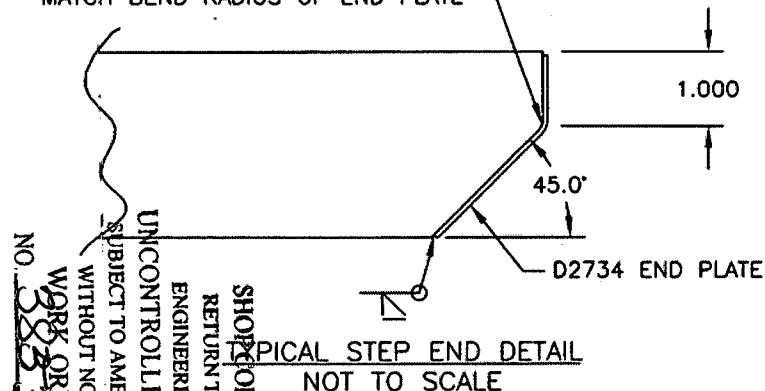
Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

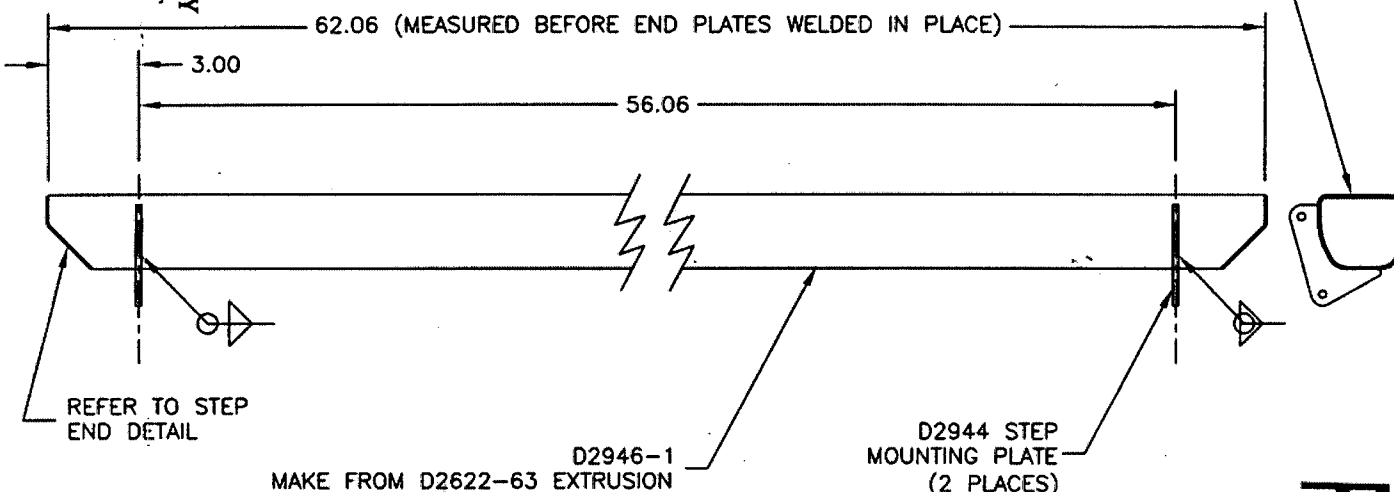
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



WORK ORDER
NO. 38837
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CH	CH	D2946
DATE	TITLE	REV. B
05.11.14	STEP ASSEMBLY	SHEET 1 OF 1
A	99.12.13	NEW ISSUE
B	05.11.14	UPDATE FINISHING NOTE

RELEASED
05.11.28